

Work Order ID 59385

June 3, 2010 10:47:31 AM

Page 1

Item ID: D3089-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor

Start Date: 6/03/10 Start Qty: 1.00

Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3089

Rev A

0.00

100



Small Fab

Small Fab

Memo

FABRICATE AS PER DWG

0.00

50Z KEVLAR BATCH: M114938
 PEEL PLY BATCH: M114938
 D3089-12 FOAM BATCH: M114938
 GEL COAT BATCH: M114938 M115135
 90Z SATIN BATCH: M11166 M113905

RT 10.07.07

10 06 16

(P10)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.06.12

AD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10 07 07	100	used Resin Hysol 956 m <u>113477</u> exp 10-12-17 Hysol 956 m <u>112167</u> exp 10-7-7 epocast 50-A1 m <u>114936</u> exp 11-6-14 ACCEPTABLE PER QA 037	ET	10-07-07		UP 10.07.12 QSI 042	S 10/07/12	

Part No: 3089-2 PAR #: Fault Category: Small Fabs NCR: ☒ Yes No DQA: Date: 10-07-12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10-07-14

NCR: 59385		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.06.30	2 100	air pockets in between gel coat + 902 cloth upon inspection. R.C. process.	UP 10.06.30 QSI 042	Fill void w/ polyester filler + prime outer edge using primer silver - structure not affected, finish only	ET 10-07-07	S 10/07/12	UP 10.06.30 QSI 042	S 10/07/12
10-07-07	100	first two layups of floor were unsuccessful. air pockets in gel coat + resin non-conforming part R.C. improper process / training		scrap + destroy floor fabricate new floor	ET 10-07-07			

NOTE: Date & initial all entries

Work Order ID 59385



Page 2

June 3, 2010 10:47:32 AM

Item ID: D3089-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor

Start Date: 6/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10-7-12 SF

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W 10-8-12



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3089	REV. A SHEET 1 OF 3
DATE 02.03.07		TITLE FLOOR	SCALE NTS
A	02.03.07	NEW ISSUE	

RELEASED
02.03.14

D3089-1/-2 FLOOR NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) USE MOLD DT8645 FOR D3089-1 FLOOR (TRIM AND DRILL Ø 0.203 PER DT8649/"D3089-A2.DWG").
USE MOLD DT8646 FOR D3089-2 FLOOR (TRIM AND DRILL Ø 0.203 PER DT8650/"D3089-A3.DWG").
- 3) ROUTER FOAM CORE USING:
DT8647 FOR D3089-11 FOAM.
DT8648 FOR D3089-12 FOAM.
- 4) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FIBER: 9oz = 9.7oz 7781 WEAVE "S" CLASS.
5oz = 5oz PLAIN WEAVE KEVLAR.
FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75.
- 5) CONSTRUCTION:
101 - GREY SURFACE FINISH PER QSI 006
102 - 9oz SATIN
103 - 5oz KEVLAR
104 - 9oz SATIN
105 - FOAM
106 - 9oz SATIN
107 - 9oz SATIN
108 - PEEL PLY
- 6) GRID SURFACE ON TOP SIDE.
- 7) NO EXPOSED KEVLAR/ NO KEVLAR IN HOLES.
- 8) ALL DIMENSIONS ARE IN INCHES.

02.03.07

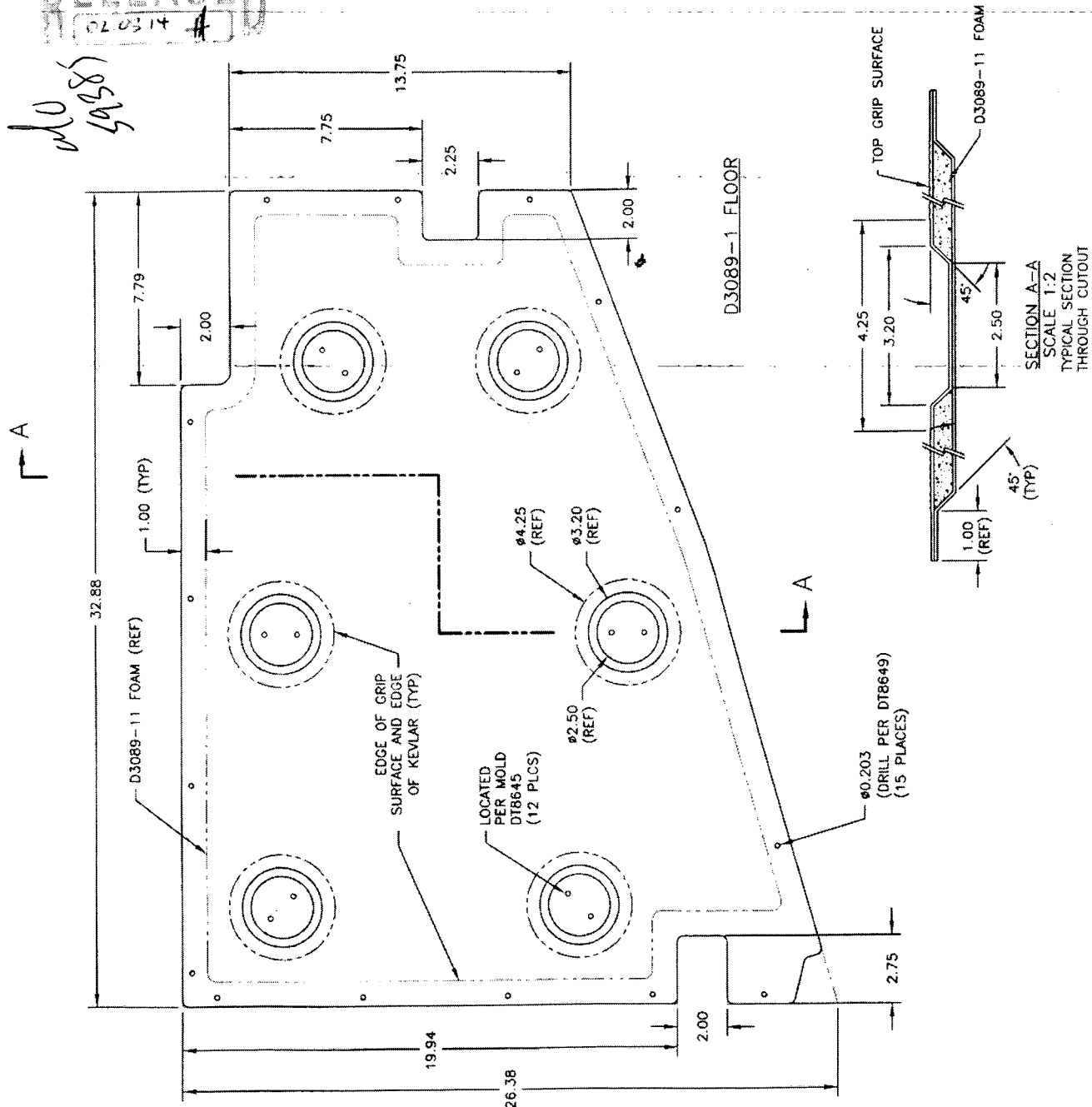
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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3089	REV. A SHEET 2 OF 3
DATE 02.03.07		TITLE FLOOR	SCALE 1:4

RELEASED
02.03.14

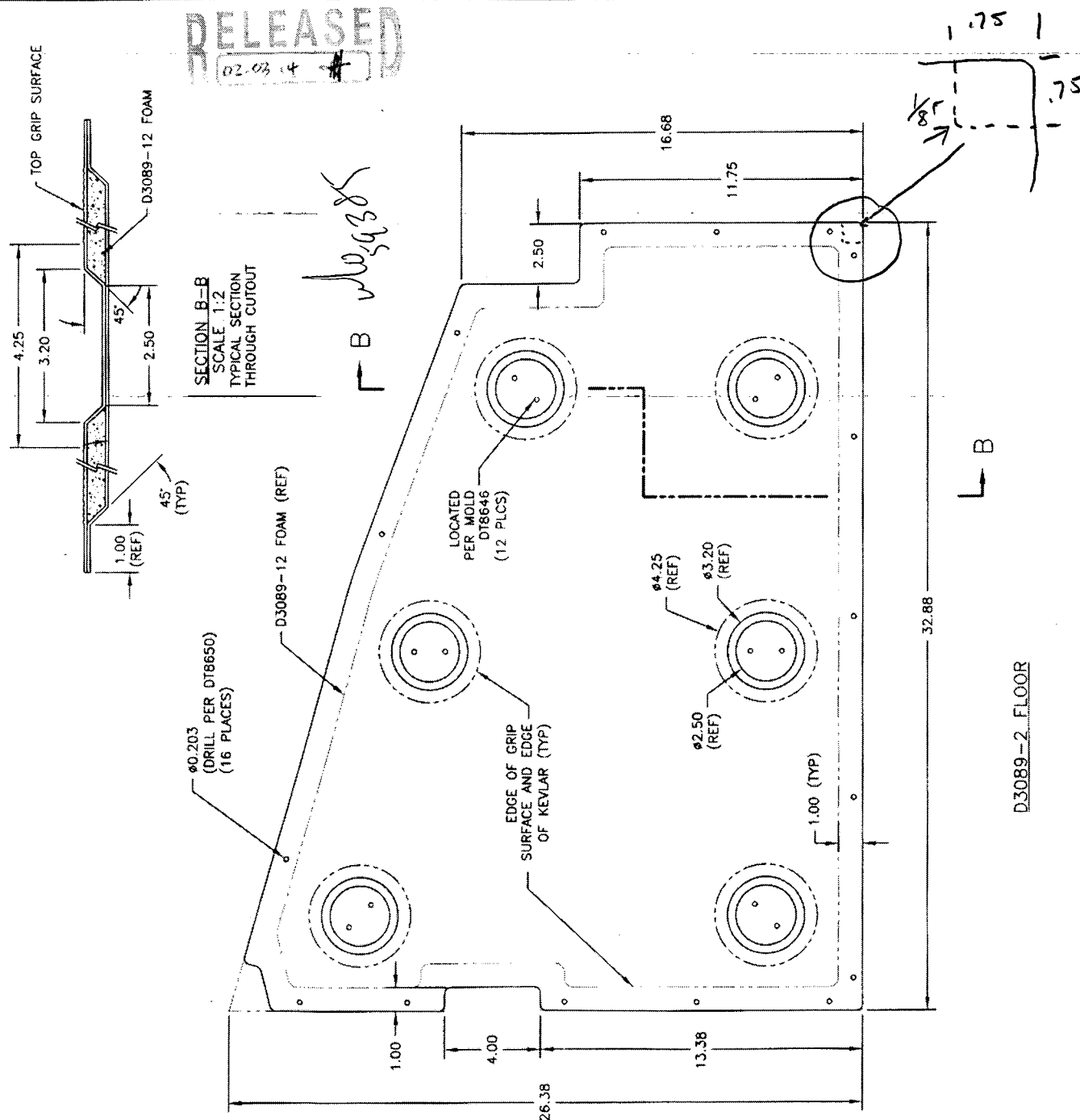


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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3089	REV. A SHEET 3 OF 3
DATE 02.03.07		TITLE FLOOR	SCALE 1:4



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DART AEROSPACE LTD.	Work Order:	
Description: Floor assembly L.H.	Part Number:	D412-697-041
Drawing: D3089 Rev.A IIn D412-697 Page	Qty:	
		Page 1 of 2

Step	Location	Procedure	By	Date	qty																				
1	EXPEDITING	Issue Work Order Type labels & photocopy paperwork as per PPP D412-697-041 Change 001																							
2	COMPOSITE	Cut/Pick: <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>4x _____ sqft</td> <td>FG-778150-550ROL</td> <td>9oz Satin</td> <td>_____</td> </tr> <tr> <td>1x _____ sqft</td> <td>81481-36</td> <td>kevlar</td> <td>_____</td> </tr> <tr> <td>_____g</td> <td>Epocast 50A</td> <td>Resin</td> <td>_____</td> </tr> <tr> <td>1</td> <td>D3089-11</td> <td>Foamcore</td> <td>_____</td> </tr> </table>	<u>Qty</u>	<u>Part number</u>	<u>Description</u>	<u>Batch</u>	4x _____ sqft	FG-778150-550ROL	9oz Satin	_____	1x _____ sqft	81481-36	kevlar	_____	_____g	Epocast 50A	Resin	_____	1	D3089-11	Foamcore	_____			
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1	D3089-11	Foamcore	_____																						
3	COMPOSITE	Apply frekote to mold DT8645 7 coats																							
4	COMPOSITE	Mask 2" around outside of mold with masking tape																							
5	COMPOSITE	Spray using grey gelcoat #944 4246 Batch: _____																							
6	COMPOSITE	Remove masking tape while gelcoat is still wet.																							
7	COMPOSITE	Scuff gelcoat well with 120 grit sandpaper																							
8	QC	Inspect level 11																							
9	COMPOSITE	Lay-up cloth as per dwg & QSI 006 (wet lay-up, bag/vacuum required) <div style="text-align: right;"> Record humidity: _____ Record temp.: _____ Record time: _____ Record Date: _____ Record vacuum: _____ </div> ***let cure min 12 hours***																							
10	COMPOSITE	After minimum 12 hour cure oven cure 2 hours @ 150°F Date: _____ Time: _____																							
11	COMPOSITE	After part has stabilized at room temperature, remove bag & demold part																							
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20	EXPEDITING	Close Work Order Inspect level 21 Job Cost / Part _____																																			

Rev	Date	Change	Revised By	Approved
A	02.03.14	New issue	NG	
B	02.03.19	Re-format	NG	

REFERENCE ONLY

DART AEROSPACE LTD.	Work Order:	
Description: Floor assembly R.H.	Part Number:	D412-697-042
Drawing: D3089 Rev.A IIn D412-697 Page	Qty:	
		Page 1 of 2

Step	Location	Procedure	By	Date	qty																				
1	EXPEDITING	Issue Work Order Type labels & photocopy paperwork as per PPP D412-697-041 Change 001																							
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Rev	Date	Change	Revised By	Approved
A	02.03.14	New issue	NG	
B	02.03.19	Re-format	NG	

REFERENCE ONLY



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33460
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
11/06/2010	07/06/2010	14346	Chantal Lavoie		PO12031		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	✓ 1	DKC-NRC-AERONA UTIQUE	Material and preparation Kevlar: 2 square yards, no. lot: 1-6904-1 Gel coat: 1 pint, no. lot: 1-27406-1 Foamcore: 2 square yards of 3/8, no. lot: 1-26978-1 Peel ply: 5 yards 			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: _____

☒ Cust.

☐ Adm.

☐ Quality

☐ Ship.

Quality department

AQ-357



NORDUYN INC.
6200, Henri Bourassa Ouest
Montréal, QUÉBEC, Canada, H4R 1C3
Téléphone : (514) 334-3210
Télécopieur : (514) 334-2989

NO EXPÉDITION: 3305
NO COMMANDE: 12786
DATE EXPÉDITION: 28 novembre 2008
EXPÉDIER PAR: Purolator
NO TRANSPORTS QUÉBEC:
COMM. CLIENT: 6804
CONNAISSEMENT:
FAB: COLLECT

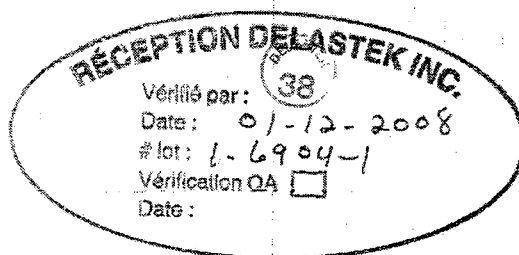
CERTIFICAT DE CONFORMITÉ

No client: D-DEC
DELASTEK COMPOSITES INC
2699, 5E AVENUE
LOCAL #14
GRAND-MÈRE QC G9T 5K7
Canada
Tél.: 819-533-5788
Télécopieur: 819-533-3494
Contact: MÉLANIE GODIN

Expédier à:
DELASTEK COMPOSITES INC
2699, 5E AVENUE
LOCAL #14
GRAND-MÈRE QC G9T 5K7
Canada
Tél.: 819-533-5788
Télécopieur: 819-533-3494
Contact: MÉLANIE GODIN

Note: Delastek Purolator account 4587471

# Produit	Description	QTE PRÉVUE	DÉJÀ EXPÉDIÉE	QTE EXP.	BO
TA-05-P-50	Kevlar 4.9oz 50" roll # 149978 lot # 3580	150	0	150	0



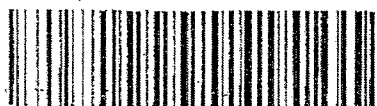
CERTIFICAT DE CONFORMITÉ

Je certifie que les articles énumérés sur la présente ont été inspectés et vérifiés et sont conformes aux spécifications et aux exigences détaillées dans le contrat ou sur le bon de commande.

SIGNÉ:

INSPECTEUR EN CHEF





FG10006361

Gurit

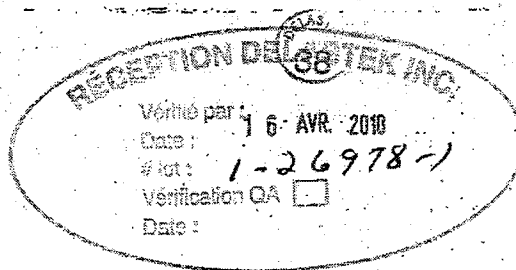
Compliance certificate for Core-Cell "A" Series

Type of sheet : A500Case # : FG10006361Order number : 24594Number of sheets : 10FT² : 319.90M² : 29.72

	Identification Number
	1002441
	1002443
	1002460

9.5 mm
-36

We hereby certify that the material listed in this document conforms to the applicable Gurit manufacturing specifications and quality criteria.

Inspected by : 780

Progress Plastiques cie 2400 rue Canadien Drummondville, Qc, J2C 7W3 Tél: 819-477-4516 Fax: 819-474-5000	CERTIFICAT D'ANALYSE
--	---------------------------------

À L'ATTENTION DE :
Numéro de fax:

Emilie Lagacé
819-533-7120

CLIENT
PRODUIT
QUANTITÉ
DATE DE FABRICATION
NO DE BATCH

DELASTEK	
944W005 Blanc	
23	kg
20-avr-10	
1004C421	

ESSAIS EFFECTUÉS	SPÉCIFICATIONS	RÉSULTATS OBTENUS
Visco 4 rpm (cPs)	17000-19000	19000
Thix ———	>6	6,73
Temps de gel (Min.)	12-15	12
DE	STD	OK

VISCOSITÉ:
CATALYSEUR:
TESTS EFFECTUÉS À 25°C

RVF#4
1.8%mekp925

PAR: France Dubois

CERTIFICAT PRÉPARÉ LE : 07-mai-10

